

Work Order ID 160935

Friday, May 05, 2017 10:20:09 AM

160935

Page 1

Item ID: PB67-43001-239W

Revision ID:

Item Name: Square Tube Weldment

Start Date: 5/9/2017 Start Qty: 7.00

Required Date: 5/12/2017 Req'd Qty: 7.00

Reference: SCHEDULED/U

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: **DAS 21 9-89** Date: **MAY 05 2017** Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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B67-43001-239	D
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110 Weld per dwg A/R Aluminum rod Batch: **131562** 0.00***110***

Large Fab

Large Fab

Memo

0.00

- 1- Cut to length as per dwg
- 2- Make a chamfer on both ends of tube
- 3- Drill holes as per dwg use drill jig DT10022
- 4- Make a chamfer on both side of the 4 holes
- 7- Deburr

DAS 24 9-89**JUN 12 2017****2****Ø****MAY 29 2017****DAS 19 9-89**

120

120

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds 0.00

CONVENTIONAL MILLING MACHINE

Memo

0.00

DAS 38 9-89**JUN 12 2017****2**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Item ID: PB67-43001-239W

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Stop ***NS2***

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Start Date: 5/9/2017 Start Qty: 7.00

7

Cust Item ID:

Required Date: 5/12/2017 Req'd Qty: 7.00

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Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	QC5- Inspect part completeness to step on W/O	0.00							
125						2			DAS 38 9-89
QC	Memo	0.00							
Quality Control									JUN 12 2017
130	Identify as per dwg & Stock Location: <u>WAB 3</u>	0.00							
130						2			DAS 24 9-89
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

JUN 12 2017

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev I

Picklist Print

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Page 1

Work Order ID: 160935

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Parent Item: PB67-43001-239W

PR67-43001-239W

Parent Item Name: Square Tube Weldment

Start Date: 5/9/2017

Required Date: 5/12/2017

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP REV:A 15.04.02 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6TS1.000W.12		Purchased	No			110	f	13.5907	1.75	12.89474			

M6061T6TS1 000W 125

6061T6 SQ TUBE 1.00 x 1.00 x .125w

**

MAY 29 2017

DAS
19
9-89

Location

MAT028

137541
m128034

Loc Qty

13.59069

13.59069

Loc Code

3.7

PB67-43001-223

Manufactured No

PR67-43001-223

Square Cap

**

JUN 12 2017

DAS
24
9-89

Location

Mezz2

152152

Loc Qty

2

2

Loc Code

B160860 → 2

PB67-43001-225

Manufactured No

PR67-43001-225

Bushing

**

JUN 12 2017

DAS
24
9-89

Location

Mezz2

148791

Loc Qty

23

23

Loc Code

B160556 → 8

JUN 12 2017

DQA: _____ Date: _____



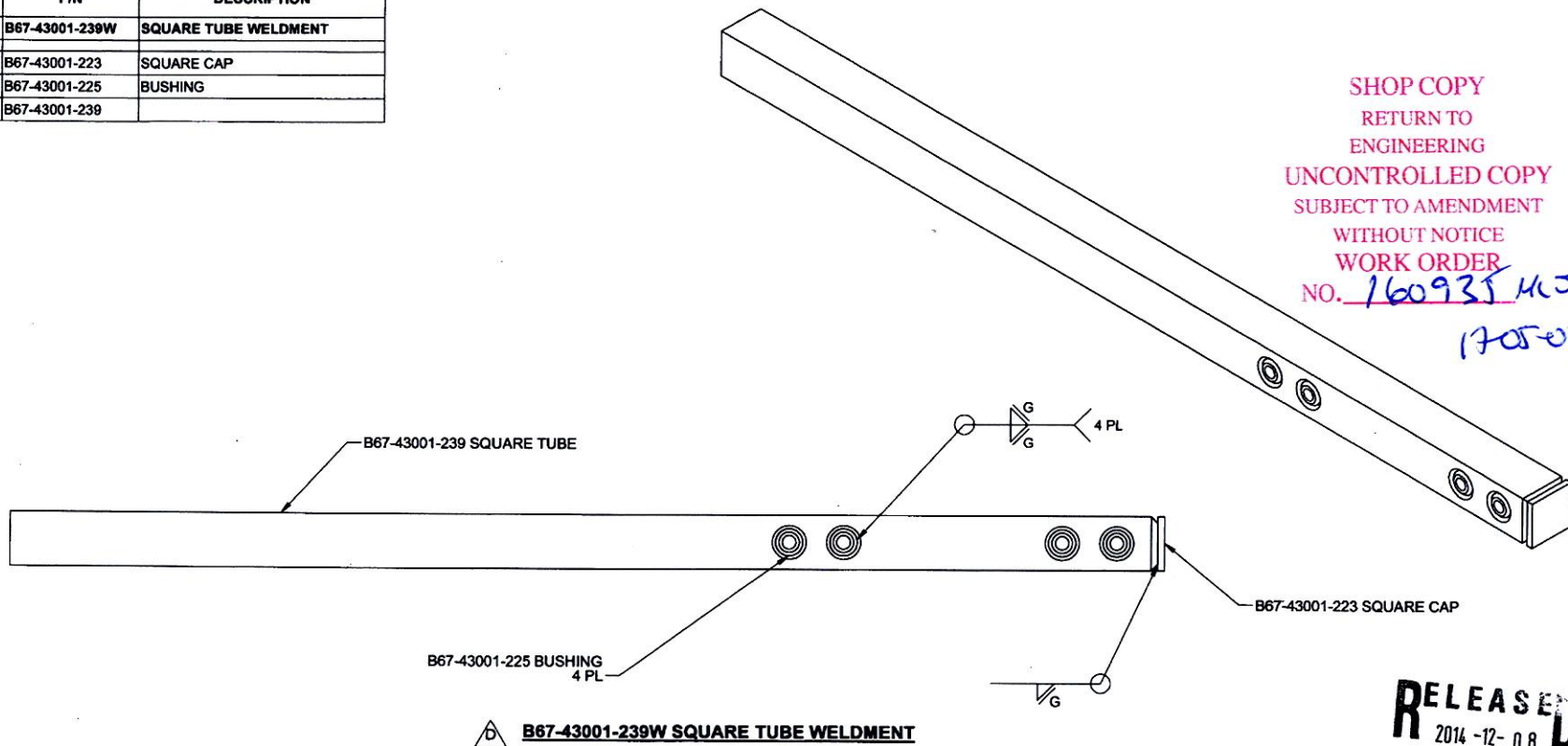
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

ITEM	QTY -239W	P/N	DESCRIPTION
	X	B67-43001-239W	SQUARE TUBE WELDMENT
1	1	B67-43001-223	SQUARE CAP
2	4	B67-43001-225	BUSHING
3	1	B67-43001-239	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160935 ML5
170505

RELEASED
2014-12-08
MD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.94 lbs
- 8) WELDING: PER DART QSI 004

D	ADD -239W WELDMENT, REMOVE CHAMFER (ZN C4-2), REASON: TO FACILITATE MANUFACTURING	DB	14.07.22
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 21 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.02.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN	DB		
CHECKED			
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	N/A		
DATE	14.07.22		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-239 TITLE SQUARE TUBE REV. D SHEET 1 OF 2 SCALE NTS COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

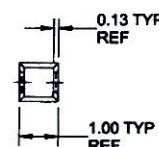
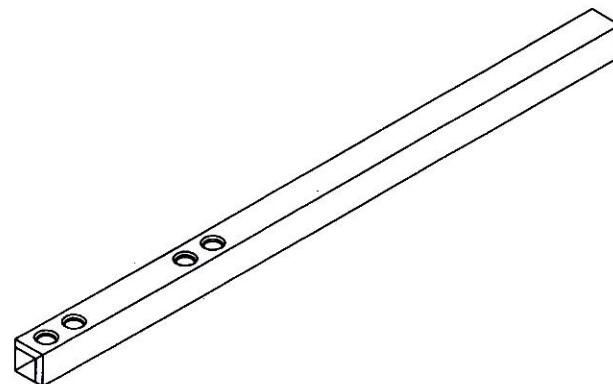
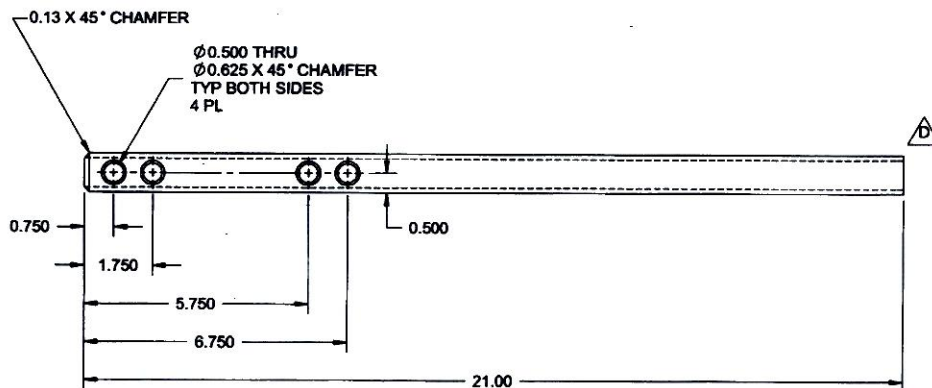
8 7 6 5 4 3 2 1

D

C

B

A



B67-43001-239 SQUARE TUBE

RELEASE
2014-12-08
W

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6TS1.000W0.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.87 lbs

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		B67-43001-239	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	SQUARE TUBE	NTS
DATE	14.07.22	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1